



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2580-1**Job Sheet 209785****Part No:** D2580-1**Job Qty:** 6 pcs**Part Name:** 205 Bent Tube**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 5/8/20**Job Tracking No:****Due Date:** 7/3/20**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG D2580 REV h SHEETS 1,2,3,8 IPP B 01.11.08 Revised Step 9, 10, 12, and 13 SM IPP Rev:C 10.12.01
as per DEO D1 DD verf:ec

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	6 pcs	7/2/20		0.00	7.69	Skidtubes - 1		DJP 20-05-21
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
101	QC 5	6 pcs	7/2/20		0.00	0.00	QC 5 - 10		DAS 03 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 5 - 82		
110	Handfinish - 1-1 Chemical-B4B	6 pcs	7/2/20		0.00	2.00	Handfinish - 1 - 1 - B4B		BFB 20-05-25
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		

**Container No:** S278876**Part:** D2580-1**Job No:** 209785**Serial No/Batch:** S278876**Revision:** H**Inspector:****Exp Date:****Instructions:** Various STC's

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/21/20

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				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
120 QC 7	6 pcs	7/2/20	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	68-6
				QC 7 - 3	30
				QC 7 - 30	DAS
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
				QC 7 - 83	
				QC 7 - 82	
				QC 7 - 87	
125 Skidtubes - 2 - B4B	6 pcs	7/3/20	0.00 2.48	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	

				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
130	QC 5	6	7/3/20	0.00 0.00	QC 5 - 10
		pcs			QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
					QC 5 - 61
					QC 5 - 81
					QC 5 - 82
140	Packaging 3-1 - Stock - B4B	6	7/3/20	0.00 0.00	Packaging 3 - 1 - B4B
		pcs			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B

5/8/2020,

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

150 QC 21 - SA

6
pcs

7/3/20

0.00 0.00

QC 21 - SA - 21

DAS

QC 21 - SA - 70

21

QC 21 - SA - 53

9-00

MAY 27 2020

Part Op 100 - (Skidtube) 1- Inspect mat'l D2500-1-190 for damage. 2-Drill pilot holes using drill jig DT 8149 A-BC-D 3-Open holes
 Descriptions: to 0.508" as per Dwg D2580 4-Debur holes per QSI002 section 4.2.3 and blow out all chips from inside of tube 5- Test fit
 inspection saddles on FWD & AFT saddle holes using DT9916.

101 - (QC5- Inspect part completeness to step on W/O)

110 - (Chemical Conversion Coat per QSI005 4.1)

120 - (QC7-Inspect Chemical Conversion Coat)

125 - (Skidtube) 1- Bond web in place per QSI 015. A/R Sikaflex-291 batch: _____ Sikaflex expire
 date: _____ Start time and date: _____ bond for 12hrs

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Identify as per dwg & Stock Location: LG002) LOCATION : LG002

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n - 'I' Beam Tube 4"	6 pcs (1 ea)	100-Skidtubes - 1	S26075
D2596	Web, 205 Skidtube	6 pcs (1 ea)	125-Skidtubes - 2 - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - 1	D2500-1-190	6	44	0
125-Skidtubes - 2 - B4B	D2596	6	0	0

Part Specifications

Specifications could not be found.

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ITEM	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
1	X	-041			D2580-041	SKIDTUBE ASSEMBLY
2			X		D2580-045	SKIDTUBE ASSEMBLY
3				X	D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-048	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2580-1-180	EXTRUSION
21			16	16	D2570	BUSHING
22	1	1	1	1	D2576-3	STEP
23	4	4			D2578	SPACER
24	16	16	8	8	D2584-1	PLUG
25	16	16	8	8	D2584-3	O-RING
26	1	1	1	1	D2586	205 WEB
27	1	1	1	1	D2585	AFT CAP
28	1	1	1	1	D3684-5	WEARSHOE
29	1	1	1	1	D3584-9	WEARSHOE
30	1	1	1	1	D3584-11	WEARSHOE
31	1	1	1	1	D3584-13	WEARSHOE
32	20	20	24	24	D4202-1	SPACER
33			1	1	D408-041	WEARPLATE ASSEMBLY
34			1	1	D408-043	WEARPLATE ASSEMBLY
35			1	1	D5081-1	FWD WEARPLATE
36			1	1	D5081-3	AFT WEARPLATE
60	60	60			AL57-1032-130 or AK57-1032-130 or AK54-1032-130 or AEL5-1032-130	INSERT
51	50	50			AN5C4A	BOLT
52	2	2	2	2	AN3-5A	BOLT
53			8	8	AN4-45A	BOLT
54	50	50			NAS1149C332R	WASHER (AN860C10L)
55	2	2	2	2	NAS1149D0332J	WASHER (AN860J10L)
56			8	8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2588 WEB POWDER COAT (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 33.7 lbs
D2580-045 = 33.7 lbs
D2580-047 = 45.1 lbs
D2580-048 = 32.0 lbs
- 8) WELDING PER DART QSI 004
- 9) INSERT D2588 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SKIAPLEX-241 ADHESIVE PER DART QSI 016 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8837 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL 60.287 HOLES FOR WEARSHOE INSERTS. INSTALL AL57-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN5C4A BOLTS AND NAS1149C332R WASHERS WITH SKIAPLEX-241-261.
- 12) INSERT D2584-1 PLUG CW D2584-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2585 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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WITHOUT NOTICE

WORK ORDER

NO. 205 08

20 05 08

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2017 JUL 05 9

ECRT-549

REV.	DESCRIPTION	BY	DATE
H	SHEET: PL DELETE D3686-1-50-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY, SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -048, -047 WEIGHT UPDATED PER DSI 8598	ALS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PART 2-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8837 WAS T25877-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 8124/8183	PH	07.04.06
C	REDRAWN, INCLUDED DEO 9004/ 9007	CP	06.08.28
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.08.16
DESIGN	DS		
DRAWN	SAD		
CHECKED	PH		
MFG. APPR.	D2580		
APPROVED	PH		
DE APPR.	PH		
DATE	17.06.09		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D2580

TITLE

205 SKIDTUBE ASSEMBLY

SCALE

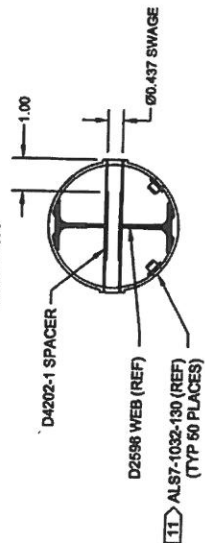
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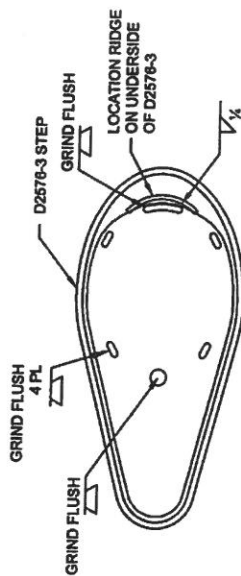
SECTION B-B
SCALE 5X



**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.608 HOLES ONLY:**

1. INSERT D402-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

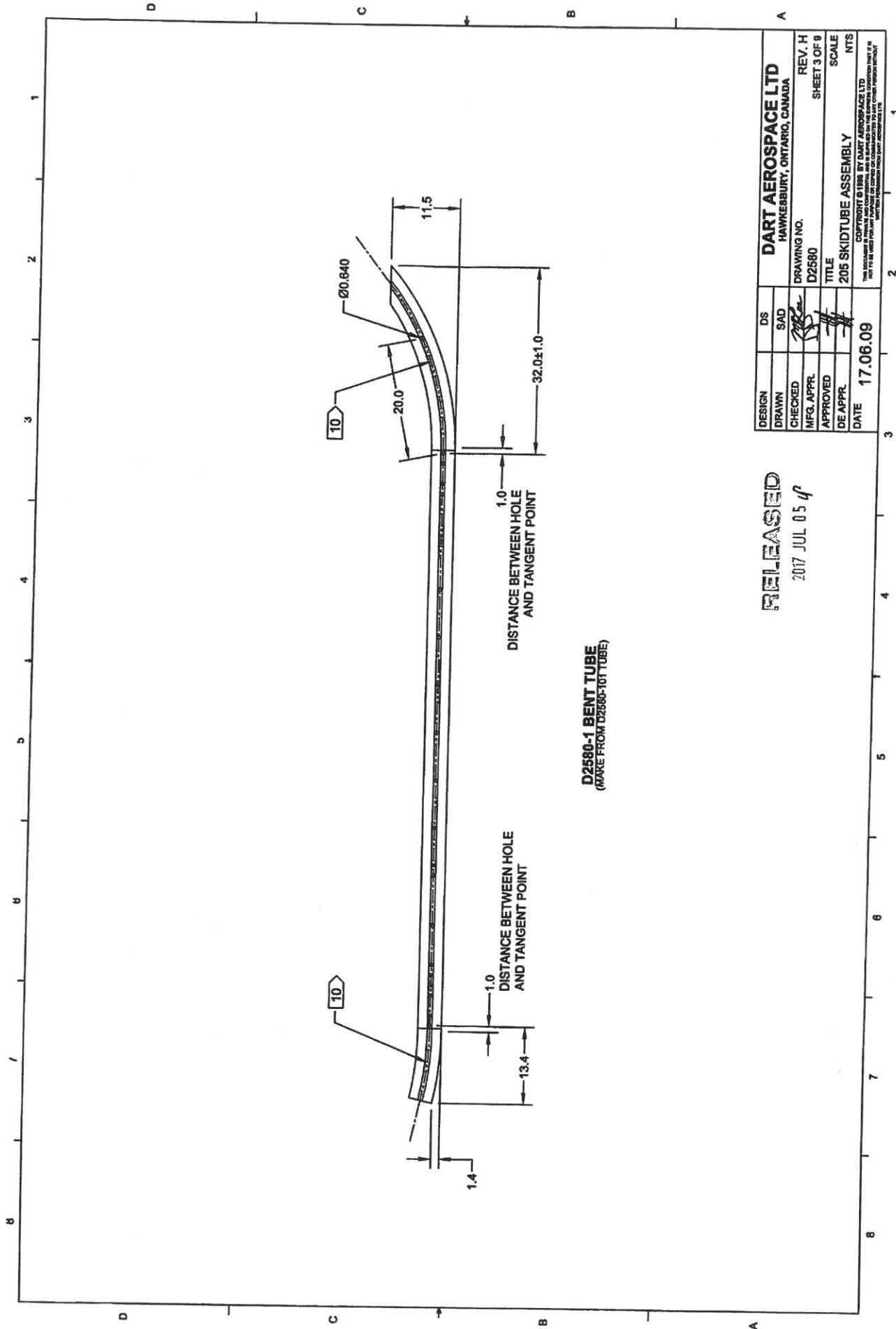
DETAIL C
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DRAWN	SAD	DRAWING NO.	REV. H
CHECKED	<i>[Signature]</i>	D2580	SHEET 2 OF 9
MFG. APPR.		TITLE	SCALE
APPROVED	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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APPROVED		TITLE 205 SKIDTUBE ASSEMBLY
DE APPR.		SCALE NTS
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Diagram of a circular component with labels: D2578 SPACER, REF (REF), and 30 (REF) PLACES.

**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT CBORE

**AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:**

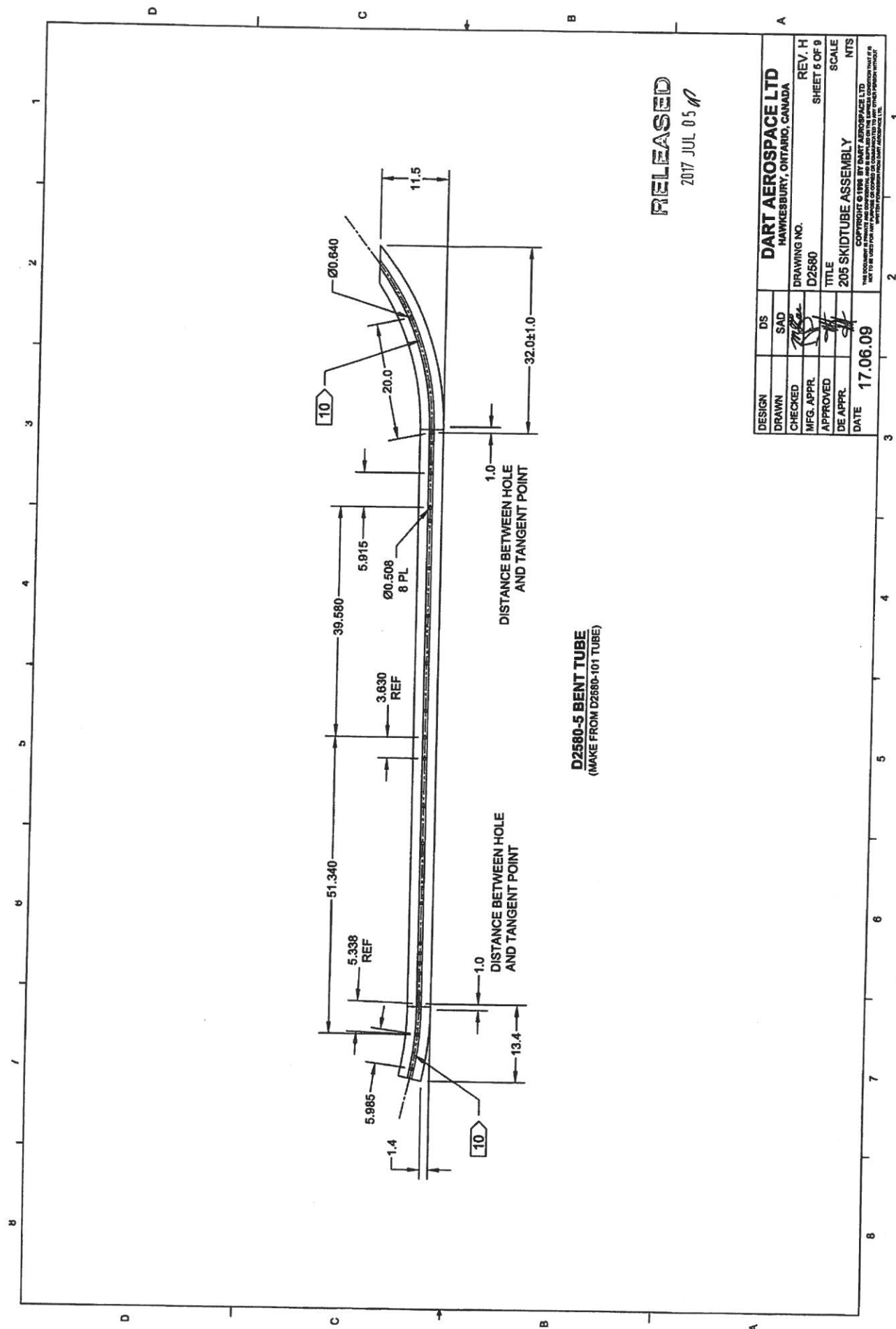
1. INSERT D402-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

Diagram illustrating the rear view of the cap assembly. The diagram shows the internal structure, including the cap body and the internal components. Key components and dimensions are labeled:

- SEAL WITH SIKAFLEX241-2B1**: Points to the seal on the left side of the cap.
- 13**: A dimension line indicating a distance of 13 units.
- Ø0.208**: A dimension line indicating a diameter of 0.208 units.
- DRILL PRIOR TO D2855 CAP INSTALLATION**: Points to the central hole in the cap.
- 2 PL**: Points to the cap body.
- AN3-5A BOLT (1)**: Points to the bolt in the center of the cap.
- WAS1149D0332J WASHER (1)**: Points to the washer in the center of the cap.
- 2 PL**: Points to the cap body.
- D2855 AFT CAP**: Points to the cap body.
- 0.40**: A dimension line indicating a distance of 0.40 units.

2017 JUL 05 4

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2580 REV. H SHEET 4 OF 9 TITLE 205 SKIDTUBE ASSEMBLY SCALE NTS COPYRIGHT © 1988 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE LOANED, REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.
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DATE	17.06.09	



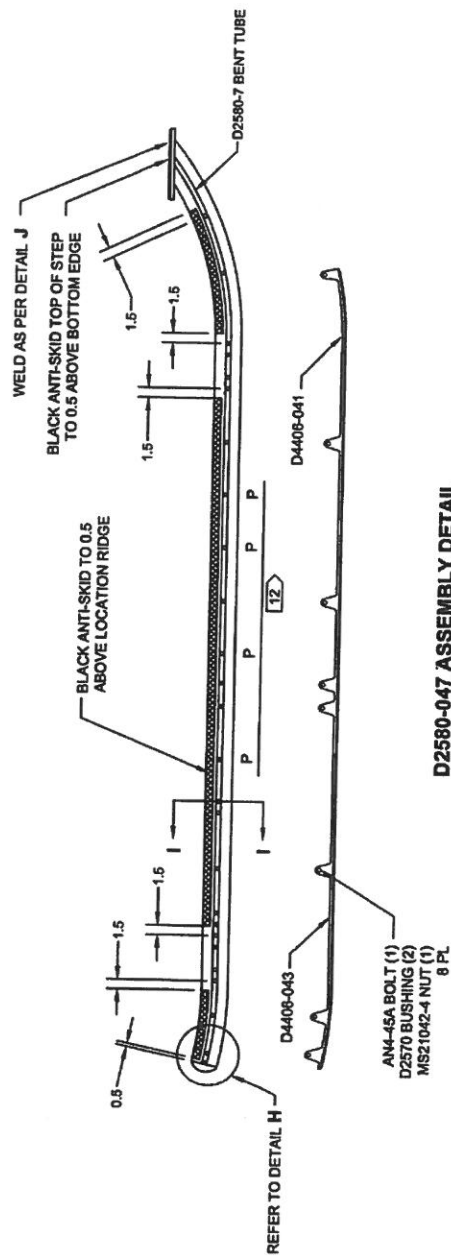
D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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APPROVED		TITLE SCALE NTS
DATE		205 SKIDTUBE ASSEMBLY
		17.06.09

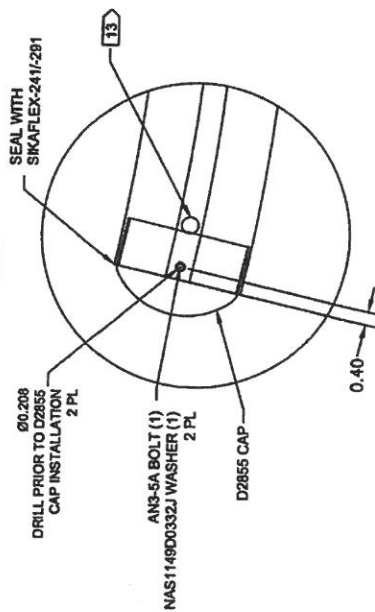
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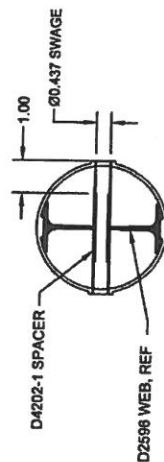


D2580-047 ASSEMBLY DETAIL

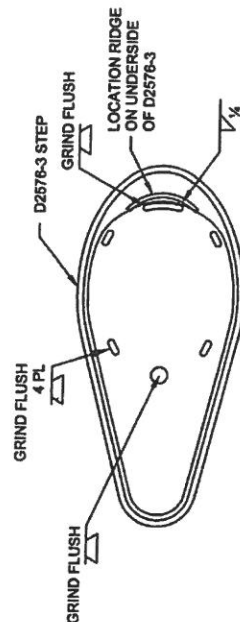
DETAIL H
SCALE 5X



SECTION I-I
SCALE 5X



DETAIL J
SCALE 5X

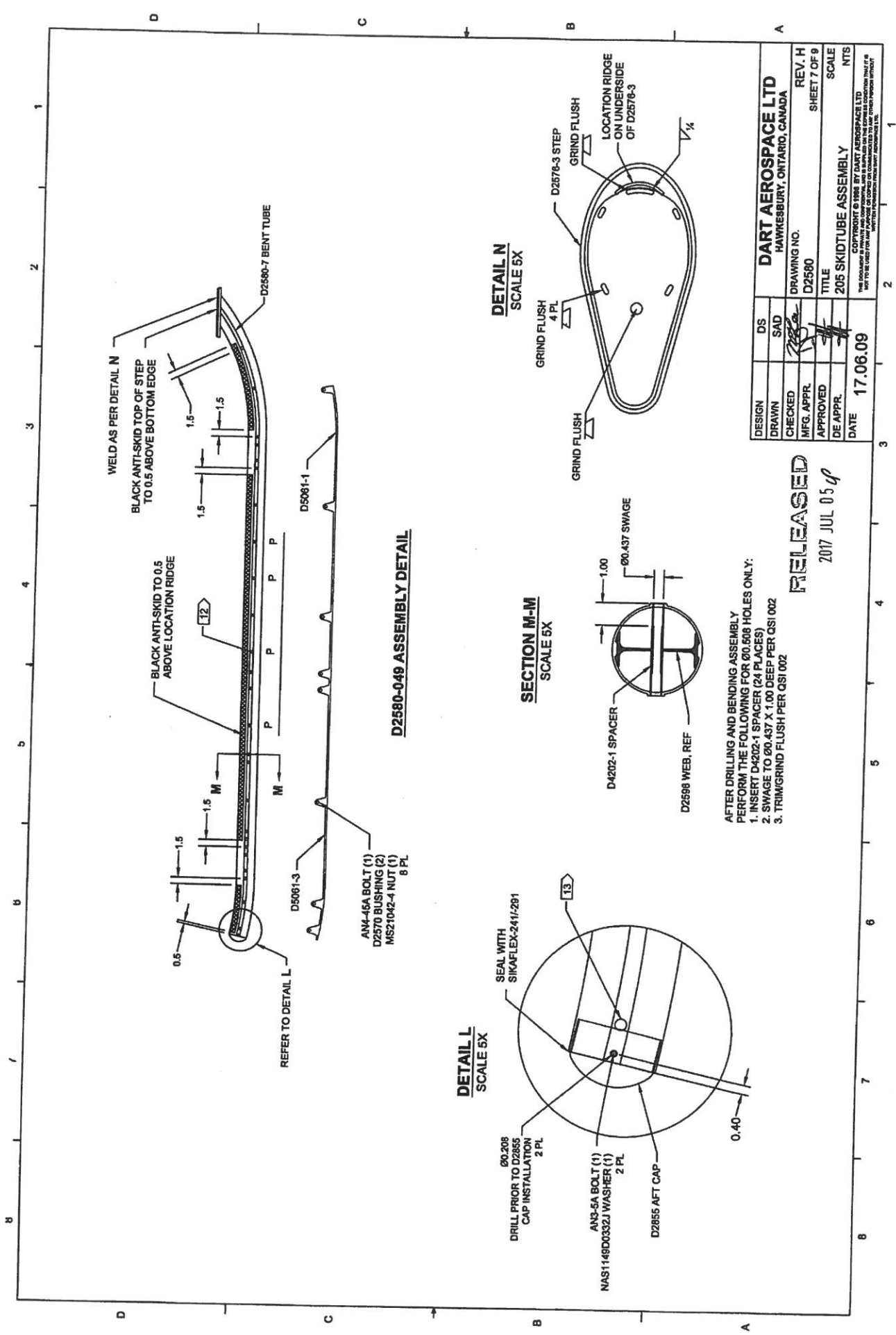


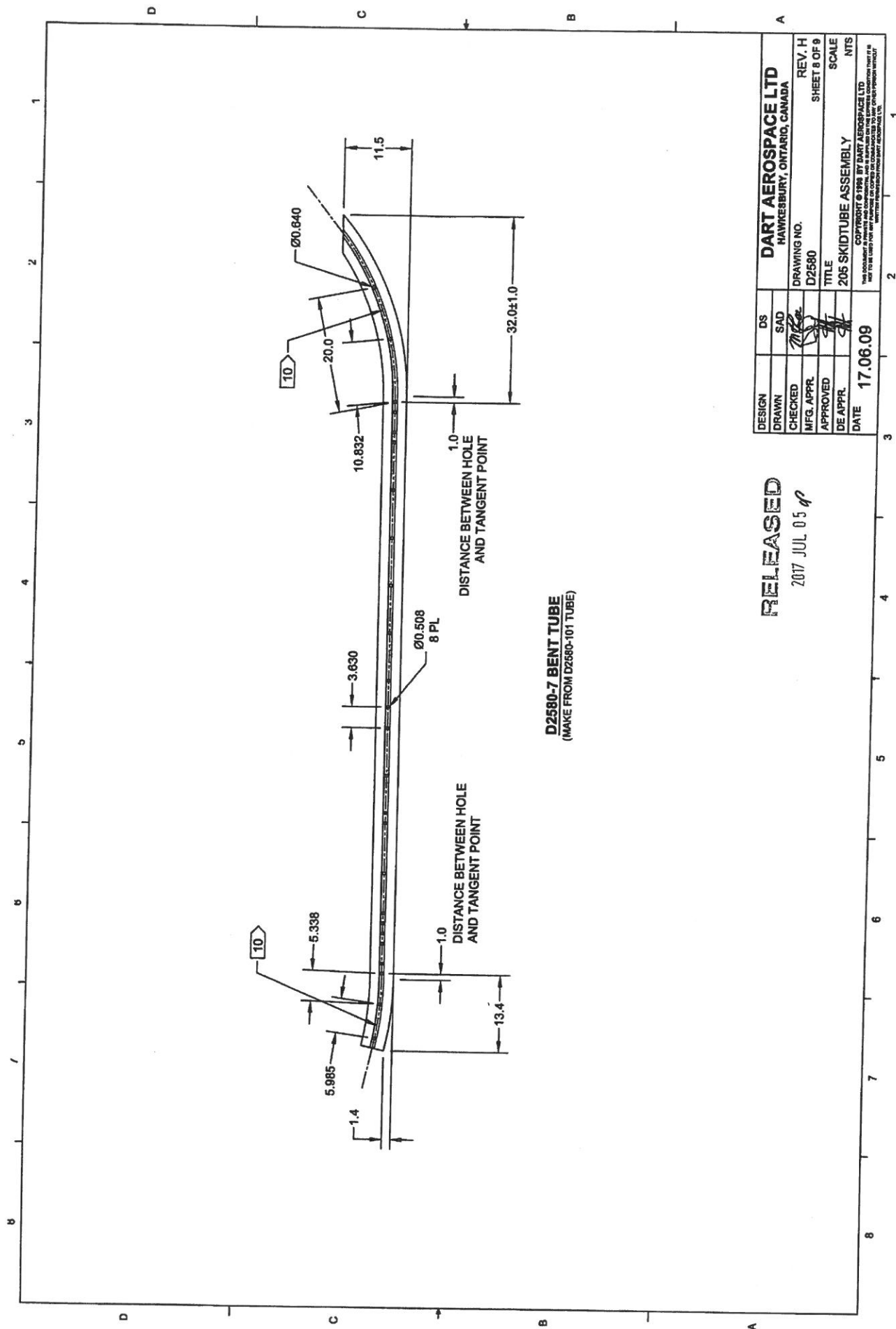
AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

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		205 SKIDTUBE ASSEMBLY
		SCALE
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D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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APPROVED		TITLE 205 SKIDTUBE ASSEMBLY
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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS		QTY Affected : _____		MRB (QSI042)																																																																																	
Date : _____		Sequence #: _____		Cross tube _____ Small Fab _____ Finishing _____		Eng. (Non-AW) _____ Prod. Eng. Coord. _____ Rec/Store/Packaging _____		Engineering _____ Water Jet _____ Supplier _____ Quality _____																																																																																	
Description Work Order Deviation				Disposition				Completed By																																																																																	
Root Cause <table border="1"><tr><td>Operator</td><td></td></tr><tr><td>Manufacturing Process</td><td></td></tr><tr><td>Equip/Tooling</td><td></td></tr><tr><td>Handling/Preservation</td><td></td></tr><tr><td>Material</td><td></td></tr><tr><td>Product Improvement</td><td></td></tr><tr><td>Process Improvement</td><td></td></tr><tr><td>Human Factors</td><td></td></tr></table>				Operator		Manufacturing Process		Equip/Tooling		Handling/Preservation		Material		Product Improvement		Process Improvement		Human Factors		FAULT CATEGORY <table border="1"><tr><td>Pressure/Forced</td><td></td><td>Contamination</td><td></td><td>Power Loss/Surge</td><td></td><td>Positioned Wrong</td><td></td></tr><tr><td>Bending</td><td></td><td>Misaligned/off center</td><td></td><td>Folio/Program</td><td></td><td>Outside Tolerance</td><td></td></tr><tr><td>Crushing</td><td></td><td>BOM/Route</td><td></td><td>Grain Direction</td><td></td><td>Drawing</td><td></td></tr><tr><td>Cracks</td><td></td><td>Broken/Damage/Defect</td><td></td><td>Weld</td><td></td><td>Finish</td><td></td></tr><tr><td>Crimp/Kink/Ripple/Wave/Twist</td><td></td><td>Incomplete/Unclear Instructions</td><td></td><td>Wrong Stock Pulled</td><td></td><td>Part Lost/Missing</td><td></td></tr><tr><td>Marks/Chatter</td><td></td><td>Drill Holes</td><td></td><td>Out of Sequence</td><td></td><td>Misread</td><td></td></tr><tr><td>Mislabeled</td><td></td><td>Fit/Function</td><td></td><td>Off-set/Set-up</td><td></td><td></td><td></td></tr><tr><td colspan="4">Other/Details:</td><td colspan="4"></td></tr></table>				Pressure/Forced		Contamination		Power Loss/Surge		Positioned Wrong		Bending		Misaligned/off center		Folio/Program		Outside Tolerance		Crushing		BOM/Route		Grain Direction		Drawing		Cracks		Broken/Damage/Defect		Weld		Finish		Crimp/Kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled		Part Lost/Missing		Marks/Chatter		Drill Holes		Out of Sequence		Misread		Mislabeled		Fit/Function		Off-set/Set-up				Other/Details:								Lead hand / Supervisor	
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